

BEST AVAILABLE COPY

JUN 15 2006 17:07 FR WL GORE LEGAL DEPT 302 292 4153 TO US PATENT OFFICE P.128/149

Y DI



Europäisches Patentamt

European Patent Office

Office européen des brevets



⑪ Publication number:

0 410 292 A2



EUROPEAN PATENT APPLICATION

② Application number: 90113783.6

⑤ Int. Cl.5: B32B 5/18, B32B 27/12,
A41D 31/02

③ Date of filing: 18.07.90

④ Priority: 24.07.89 US 384574

⑦ Applicant: W.L. GORE & ASSOCIATES, INC.NC.
551 Paper Mill Road P.O. Box 9206
Newark, Delaware 19714-9206(US)

⑥ Date of publication of application:
30.01.91 Bulletin 91/05

⑧ Inventor: Sakhpura, Dilip
159 Boyer Drive
Newark, Delaware 19702(US)

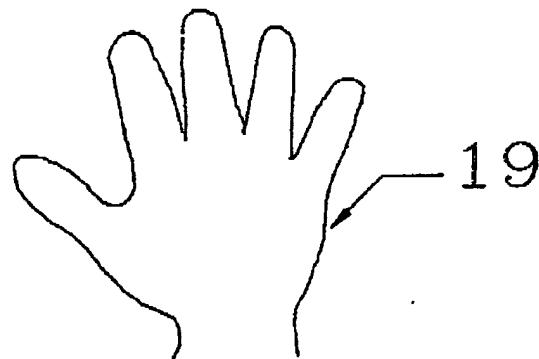
⑨ Designated Contracting States:
DE FR GB IT SE

⑩ Representative: Klunker . Schmitt-Nilsson .
Hirsch
Winzererstrasse 106
D-8000 München 40(DE)

⑪ Insert for lining articles of clothing.

⑫ The invention herein is directed to providing a strong uniformly welded seam in new inserts for articles of clothing, that are easily slidable over the inner protective lining of the clothing.

Figure 1



EP 0 410 292 A2

Xerox Copy Centre

PAGE 128/149 * RCVD AT 6/15/2006 4:34:16 PM [Eastern Daylight Time] * SVR:USPTO-EFXRF-6/34 * DNIS:2738300 * CSID:302 292 4153 * DURATION (mm:ss):29:28

FIELD OF THE INVENTION

The present invention relates to a watertight insert for lining articles of clothing, in particular gloves, shoes and caps, and to methods for producing it.

BACKGROUND OF THE INVENTION

Watertight but water vapor-permeable membrane material exists which has been used increasingly in recent years for the production of watertight articles of clothing. Due to its vapor permeability it results in pleasant wearing properties. Such membrane material is made, for example, of expanded microporous polytetrafluoroethylene (usually abbreviated to PTFE).

More recently, such membrane material has also been used for producing watertight articles of clothing such as shoes, gloves and caps. Such articles of clothing are lined on the inside at least partly with a functional layer consisting of such membrane material.

These inserts have a seam that follows the contour of the desired article. These seams are a problem because they are potential sites of water penetration. For this reason a watertight insert for clothing is conventionally produced by rolling two membrane films off separate supply rolls and directing them superimposed into a welding unit where they are welded together by means of a welding form along a contour path corresponding approximately to the contour of the article of clothing. Since this kind of insert is initially a two-dimensional structure, it is oversized so that the part of the body to be clothed, for example the hand in the case of a glove, fits into the insert comfortably enough.

It has turned out that the welding seams of such inserts are mechanical weak points which can tear if the inserts are handled inexpertly during production of the corresponding clothing.

Glove production shall be taken as an example. The insert having an outer contour corresponding to the finished glove is usually placed over a rough wooden model of a hand or a wooden model with liner material already on it. Some of these inner lining materials include insulations that exhibit friction between the two surfaces. It often happens that these two actions are performed too vigorously so that the insert tears at the welding seam. In particular when tearing occurs during the placing of the outer covering of the glove, it goes unnoticed. But

also when the insert is accidentally placed over the wooden model of the hand in such a way that two fingers of the wooden model go into one and the same finger of the insert, this may over strain the watertight insert and cause a tear at its welding seam.

SUMMARY OF THE INVENTION

The invention herein is directed to inserts of articles of clothing and to providing a strong uniformly welded seam in the inserts and to providing inserts that easily slide over an inner protective lining of the glove.

The process aspect of the invention comprises:

- 1) laminating a sheet of porous polymeric membrane that is breathable but waterproof and that is coated with a hydrophilic polymer, to a sheet of textile material by using a discontinuous adhesive of a thermoplastic polymer,
 - 2) placing two of said laminates together to form a layered structure with the sheets of textile material adjacent one another in abutting relationship,
 - 3) bonding said laminates together along a contour path by causing the thermoplastic adhesive polymer to flow together through the textile material layers of each laminate.

The product aspect of the Invention comprises a waterproof insert for lining the interior of contoured articles of clothing, which comprises:

two superimposed layers, each of which is a laminate composed of a sheet of porous polymeric membrane that is breathable but waterproof and is coated with a hydrophilic polymer, said layers being laminated by a discontinuous adhesive of thermoplastic (remeltable) polymer to a sheet of a textile material.

said laminates being superimposed so that the sheets of textile material are in adjacent, abutting relationship.

said laminates being joined along that portion of the laminates that lie in a path that follows the contour of the article of clothing.

said joining being achieved by the presence of said adhesive throughout the area of the textile materials of each laminate adjacent the contour path and by interconnection of the adhesive from each laminate at the abutting surface of the textile material.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 shows a glove insert looking down from the top where the heavy line represents the contour path.

Figure 2a shows a cross-section of the insert in a "separated" form before the two laminates are bonded together along the contouring path.

Figure 2b shows a cross-section of the insert after bonding has taken place along the contour path.

Figure 3 depicts schematically the preparation of laminates used in the invention.

Figure 4 depicts a top view of a typical sealing die used to bond two laminates to form the contoured seam on the insert.

Figure 5 depicts the die in position to bond the adjacent layers of laminated material.

DETAILED DESCRIPTION OF THE INVENTION

The waterproof breathable porous polymeric membrane is preferably an expanded porous PTFE membrane, such as is described in U.S. patents 3,953,568 and 4,187,390, or a microporous polyolefin or the like. Preferably the membrane will be expanded porous PTFE. For the inserts of the invention the membrane weight is preferably 10 gm. per square yard to 25 gm. per square yard. By "breathable" is meant that the material permits water vapor to be transferred through it, but is impermeable to liquid water (waterproof).

The hydrophilic polymer is preferably a breathable polyether polyurethane coating or a per-fluorosulphonic. These coatings on the porous breathable membrane are more fully described in USP 4,194,041.

The textile material may be a woven, non-woven or knit or the like. It provides abrasion resistance to the porous membrane. It provides non-blockiness to the laminate, and aids in inserting the insert into a glove. It also provides dimensional stability to the insert. The preferred textile material is non-woven and has a weight of between 5.6 gm./square yard to 28 gm./square yard. The air flow capability or porosity through the textile material should be adequate enough for the adhesive to flow easily through it. The preferred textile material should also be thin so that the thickness of this substrate is totally encapsulated by the adhesive. Preferred thickness is less than 10 mils, more preferred is less than 5 mils. The preferred textile materials are made of polyester, nylon, and the like.

The adhesive adheres the textile fabric to the porous membrane/hydrophilic coating (composite)

and is used to adhere the two laminates together at the contour seam by flowing through the open spaces (pores) in the textile fabric. The adhesive can be either a "breathable" or a nonbreathable adhesive as described in USP 4,532,316. Preferably the adhesive will have a weight of between 7 and 40 gm. per square yard. The adhesive can be a polyester adhesive or a polyurethane adhesive.

5 The adhesive is activated by thermal, high-frequency or ultrasonic energy, which causes the adhesive to melt. Pressure and the inherent liquid-proof nature of the membrane are both utilized to cause the melted adhesive to flow through the textile material and adhere to adhesive flowing through the textile material in the other laminate.

10 The adhesive can be applied to the membrane in a discontinuous (or dot) pattern by a solvent technique or by hot melt techniques. For hot melt application, extrusion or drum unloading delivery can be employed with a lamination line as shown in Figure 3.

15 Preferably the adhesive will have a melting point between 40 and 200 °C. It also preferably will have a low viscosity at or above the melt point to aid flow through the textile material.

20 To produce the inserts of the invention, the adhesive is applied in a discontinuous fashion to the coated side of the porous coated membrane end then the textile material bonded to form a laminate. Two laminates are then placed together and then the adhesive is activated along the contour path, preferably using a sealing die. The type of activation will depend on the adhesive. Most commonly, the remeltable adhesive will be one that is heat activated. On activation around the contour, the adhesive in each laminate melts and flows inwardly through the textile material of each layer until the remeltable adhesive from each laminate meets and bonds with itself to form a solid strong bond.

25 Referring now to Figure 1, a glove insert is depicted shown from the top. The contour line is shown by heavy line 19.

30 Figure 2a shows the insert of the invention in separated form before the two laminates are sealed along the contour path. The porous membranes are shown by 1 and 1¹, the breathable adhesive by 2 and 2¹, and the textile material by 3 and 3¹.

35 Figure 2b shows the same insert as in 2a, but after the heat activation step. Figure 4 depicts those portions of the textile material through which the adhesive passes on melting, and has bonded to itself. The adhesive meets at the interface of the textile material of each laminate to form a strong bond.

40 An advantage of this invention is that the adhesive bonds to itself in a very thin coating without leaving an excessive residuum at the interface on the

surface of 3 and 3'. This contrasts to applying adhesive in the form of a bead between the laminates which can leave a thick seam area at the point of seal. Also, by stamping and bonding the entire contour at the same time, the production speed is greatly enhanced.

EXAMPLE 1

The adhesive was prepared as follows: 23.45 gms. of MDI (4, 4'-diphenylmethane diisocyanate) was charged to a reactor at 50°C then 23.45 gms. of 1000 molecular weight poly(oxytetramethylene) glycol was added to the reactor, followed by 46.90 gms. of 2000 molecular weight poly(oxytetramethylene) glycol. The reaction was allowed to go to completion as determined by % NCO titration. Then, 2.82 gms. of 1, 4-butanediol was added and stirred for 10 minutes followed by addition of 3.38 gms. of octadecanol and stirred for 15 minutes. The reaction mass was then dumped into a container.

Microporous expanded polytetrafluoroethylene (PTFE) obtained from W. L Gore & Associates was first coated with a hydrophilic layer of polyurethane (8-12 gms./sq. yd.) as described in USP 4,194,041 to prevent the micropores from getting contaminated with impurities such as sweat, etc. To this coated side of the resulting composite 4 was applied a layer of the polyurethane adhesive 3 (8-30 gms./sq. yd.) in a discontinuous (dot) pattern, and before this adhesive completely solidified a thin layer of 14 gms./sq. yd. weight textile fabric 5, non-woven, trade name Lutrabond, was bonded to it to make a laminated structure, which was wound on roll 8. Rolls 1 and 2 aid in guiding the materials through out the process. Hot melt adhesive was applied with doctor blade 6.

Two such laminated layers were put on top of each other with the textile fabric sides facing each other and using a heated die in the form of a glove, a glove was prepared by heating the die to 230°C and closing the press for 1 second. Figures 4 and 5 depict this step. Die 23 contains heating element 22. Element 22 is constructed to fit the contour line of the glove. 23 represents the die base or support while 22 is the heated die element. The die is placed on the two laminates 20 and 21. The die is heated effecting sealing of the two laminates along the contour path. Thus, a glove insert is obtained.

The glove insert so formed was found very easy to slide over a glove form. The glove was tested as follows: peel strength (at break) was 5.54 pounds, and the MVTR was 5700 gm./meter²/24 hours.

Peel strength was determined by using a standard Instron tester using one inch wide specimens at 50% strain rate.

MVTR was determined as described in U.S. serial number 252,832 filed October 3, 1988, allowed April 6, 1989 in the name of P. M. Crosby using sodium chloride as the salt.

70 Claims

1. A waterproof insert for lining the interior of contoured articles of clothing, which comprises: two superimposed layers, each of which is a laminate composed of a
 - a sheet of porous polymeric membrane and,
 - b) a sheet of a textile material,
 said porous polymeric membrane being breathable but waterproof and being coated with a breathable hydrophilic polymer, said sheets being laminated by a discontinuous adhesive of thermoplastic polymer,

said laminates being superimposed so that the sheets of textile material are in adjacent, abutting relationship,

said laminates being joined along that portion of the laminates that lie in a path that follows the contour of the article of clothing,

said joining being achieved by the presence of said adhesive throughout the area of the textile materials of each laminate adjacent the contour path and by interconnection of the adhesive from each laminate at the abutting surface of the textile material.
2. The insert of Claim 1 wherein the porous membrane is expanded polytetrafluoroethylene.
3. The insert of claim 1 or 2 wherein the textile material is a non-woven.
4. The insert of claim 1, 2 or 3 wherein the adhesive is a polyurethane.
40. Process for manufacturing a waterproof insert according to claim 1 comprising the following steps:
 - 1) laminating a sheet of porous polymeric membrane that is breathable but waterproof and is coated with a breathable hydrophilic polymer to a sheet of textile material by using a discontinuous adhesive of a thermoplastic polymer,
 - 2) placing two of said laminates together to form a layered structure with the sheets of textile material adjacent one another in abutting relationship,
 - 3) bonding said laminates together along a contour path by causing the breathable thermoplastic adhesive polymer to flow together through the textile material layers of each laminate.
55. Process of Claim 5 wherein the porous membrane is expanded polytetrafluoroethylene.
7. Process of claim 5 or 6 wherein the textile

7

EP 0 410 292 A2

8

material is a non-woven.

8. Process of claim 5, 6 or 7 wherein the adhesive
is a polyurethane.

9. Process of claim 8 wherein the adhesive is
caused to flow by applying heat to the layered 5
laminates.

10

15

20

25

30

35

40

45

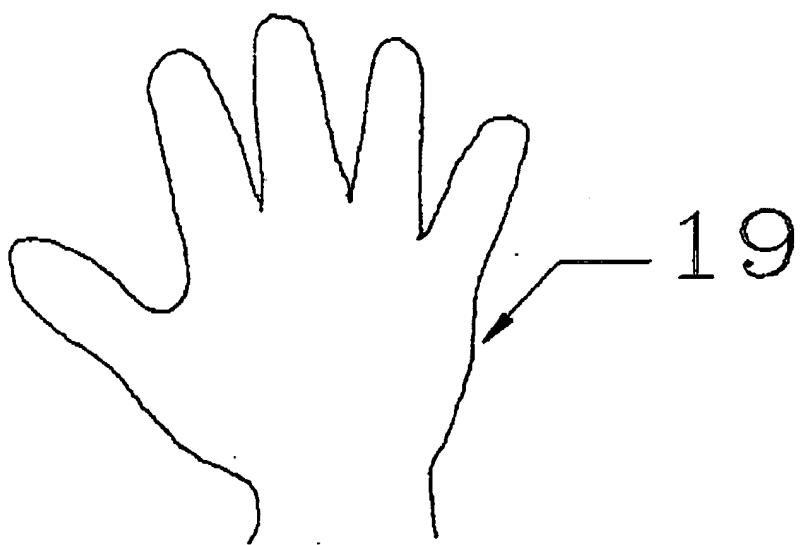
50

55

6

EP 0 410 292 A2

Figure 1



EP 0 410 292 A2

Figure 2

Figure 2a

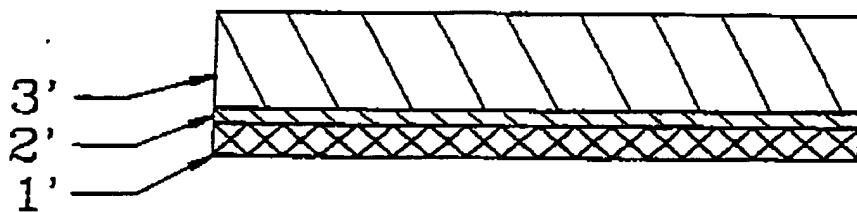
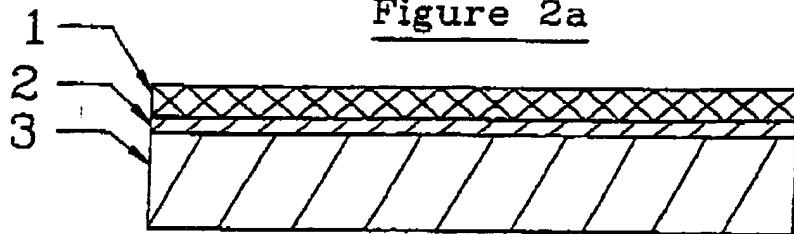
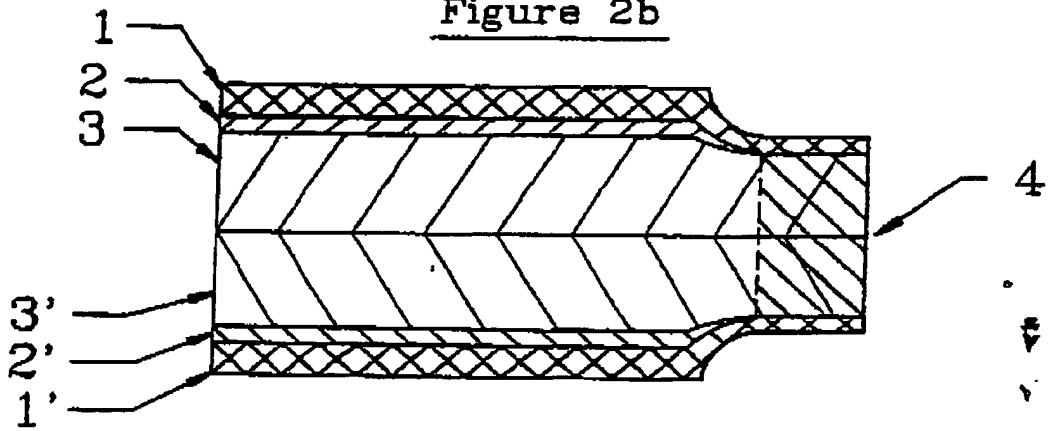
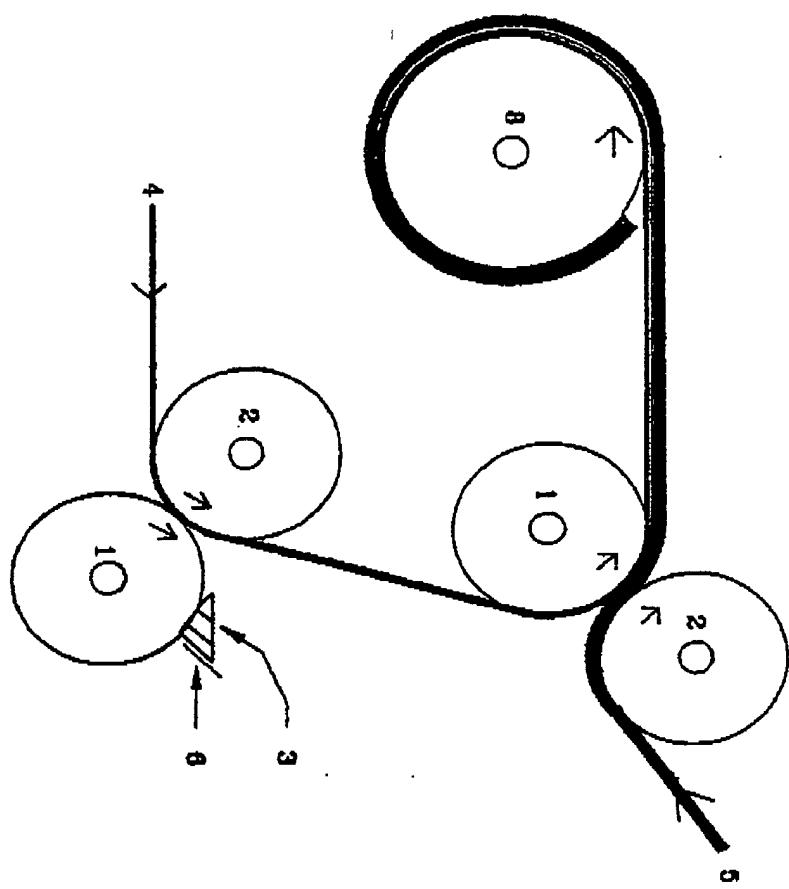


Figure 2b



EP 0 410 292 A2

Figure 3



EP 0 410 292 A2

Figure 4

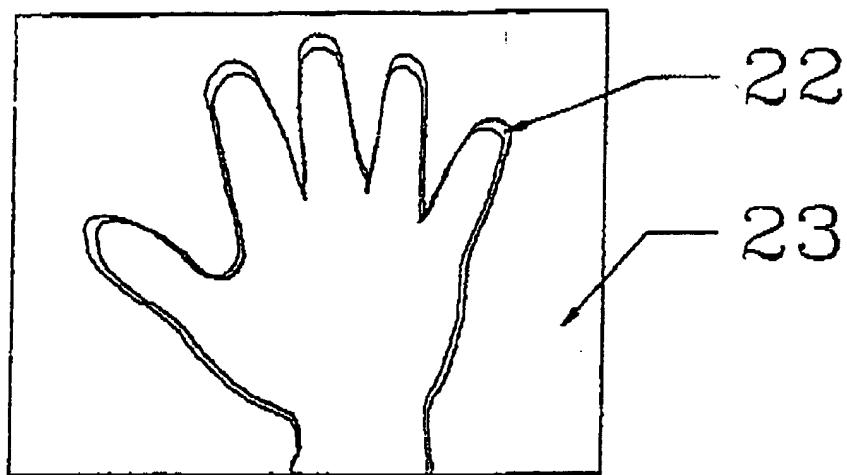
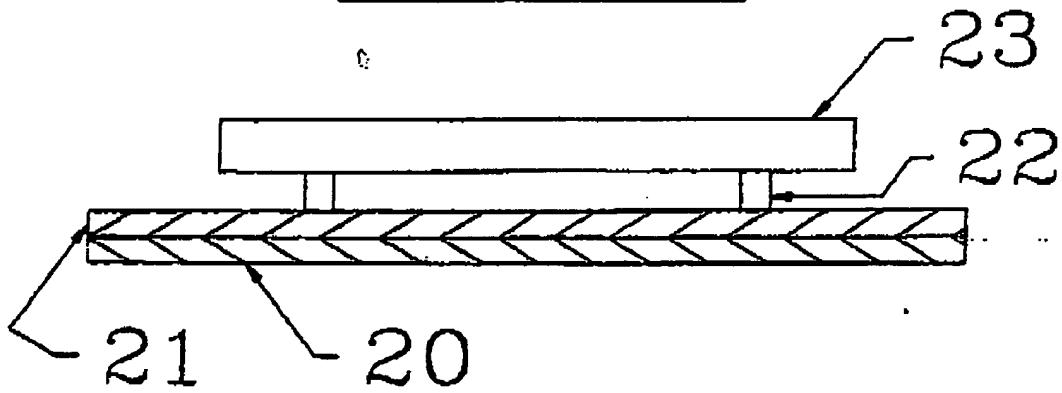


Figure 5



European
Patent OfficeEUROPEAN SEARCH
REPORT

Application Number

EP 90 11 3783

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)		
			TECHNICAL FIELDS SEARCHED (Int. Cls.)		
Y	US-A-4 185 330 (STAGER) " Column 2, lines 45-62 "	1,2,5,6	B 32 B 5/18 B 32 B 27/12 A 41 D 31/02		
Y	GB-A-2 155 853 (NITTO ELECTRIC IND. CO.) " Page 4, lines 13-27 "	1,2,5,6			
A	EP-A-0 202 996 (CHEMICAL FABRICS CORP.) " Column 7, lines 18-42; column 8, lines 17-42; figure 2 "	1-3,4-7,9			
A	EP-A-0 263 665 (JAPAN GORE-TEX) " Whole document "	1-3			
A	DE-U-8 714 816 (VOACK) " Claims 1,2,5; figures "	1			
P.A	EP-A-0 345 730 (W.L. GORE) " Claims 1,5,7; column 6, line 58 - column 7, line 5 "	1-8			
The present search report has been drawn up for all claims			B 32 B A 41 D		
Place of search	Date of completion of search	Examiner			
The Hague	16 July 91	MCCONNELL C.H.			
CATEGORY OF CITED DOCUMENTS					
X:	particularly relevant if taken alone				
Y:	particularly relevant if combined with another document of the same category				
A:	technological background				
O:	non-written disclosure				
P:	intermediate document				
T:	theory or principle underlying the invention				
E:	earlier patent document, but published on, or after the filing date				
G:	document cited in the application				
L:	document cited for other reasons				
R:	member of the same patent family, corresponding document				



Europäisches Patentamt
European Patent Office
Office européen des brevets



② Publication number:

0 410 292 A3



EUROPEAN PATENT APPLICATION

② Application number: 90113783.6

⑤ Int. Cl. 5: B32B 5/18, B32B 27/12,
A41D 31/02

③ Date of filing: 18.07.90

④ Priority: 24.07.89 US 384574

⑦ Applicant: W.L. GORE & ASSOCIATES, INC.
551 Paper Mill Road P.O. Box 9206
Newark, Delaware 19714-9206(US)

④ Date of publication of application:
30.01.91 Bulletin 91/05

⑦ Inventor: Sakhpara, Dilip
159 Boyer Drive
Newark, Delaware 19702(US)

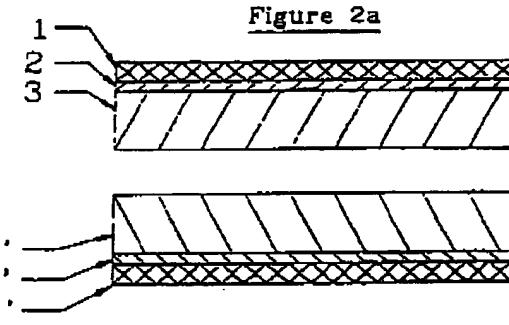
④ Designated Contracting States:
DE FR GB IT SE

⑦ Representative: Klunker . Schmitt-Nilson .
Hirsch
Winzererstrasse 106
W-8000 München 40(DE)

④ Date of deferred publication of the search report:
23.10.91 Bulletin 91/43

⑥ Insert for lining articles of clothing.

⑤ A waterproof insert for lining the interior of contoured articles of clothing is described, which comprises two superimposed layers, each of which is a laminate composed of a sheet of porous polymeric membrane (1, 1') and a sheet of textile material (3, 3'), the said sheet of polymeric membrane being breathable but waterproof and coated with a breathable, hydrophilic polymer. The sheets are laminated by means of a discontinuous adhesive (2, 2') and the layers are joined to form a uniformly welded seam. The inserts slide easily over the inner protective lining of the article of clothing.



EP 0 410 292 A3

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- BLACK BORDERS**
- IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**
- FADED TEXT OR DRAWING**
- BLURRED OR ILLEGIBLE TEXT OR DRAWING**
- SKEWED/SLANTED IMAGES**
- COLOR OR BLACK AND WHITE PHOTOGRAPHS**
- GRAY SCALE DOCUMENTS**
- LINES OR MARKS ON ORIGINAL DOCUMENT**
- REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**
- OTHER: _____**

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.